

19-7725

DEBATCHU



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RBT18402-1
Job Sheet 197578



Part No: RBT18402-1		Job Qty: 32 pcs
Part Name: Jack Weldment		
Part Weight: 0 lbs	Status: Scheduled	Priority: Medium
Job Created: 7/10/19	Job Tracking No:	
Due Date: 8/27/19	Created By: Marie Lajeunesse	
Type: SOLD	Description:	
Note: DWG RBT18402 Rev 1A IPP Rev. A 19.07.03 New issue DP Verify DD		
Ship Via:		

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Welded Assy-1	32 pcs	8/27/19	8/27/19	0.00	10.67	Large Fab - 1		ML
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 5	32 pcs	8/27/19	8/27/19	0.00	10.67	QC 5 - 10		N/A
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
115	Conventional Lathe - 1 - B4B	32	8/27/19	8/27/19	0.00	3.20	Conventional Mill - 1 -		



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Container No: S206068



Part: RBT18402-1
Job No: 197578
Serial No/Batch: S206068

Revision: 1A
Inspector:
Exp Date:
Instructions:

Date: 08/15/19

pcs				B4B		
				Conventional Mill - 2 - B4B		
120 QC 5	32 pcs	8/27/19	0.00	0.00	QC 5 - 10	N/A
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
130 Large Fab - Basket - 2 - B4B	32 pcs	8/27/19	0.00	21.33	Large Fab - 1 - B4B	N/A
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
140 QC 9	32 pcs	8/27/19	0.00	0.00	QC 9 - 10	EL
					QC 9 - 18	
					QC 9 - 24	
					QC 9 - 43	
					QC 9 - 50	
					QC 9 - 9	
150 QC 5	32 pcs	8/27/19	0.00	0.00	QC 5 - 10	EL
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	

Plex 8/15/19 2:49 PM dart.larocque.eric

160 Powdercoat - 6 Fire Red - B4B	32 pcs	8/27/19	0.00 1.07	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	BEB 19-08-16
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
170 QC 3	32 pcs	8/27/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	ML 14-9-14
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
180 Large Fab - Welded Assy-3-B4B	32 pcs	8/27/19	0.00 10.67	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	ML
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
190 QC 5	32 pcs	8/27/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EL
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
200 Handfinish - 4-1-Assembly-	32	8/27/19	0.00 2.13	Handfinish - 4 - 1 - B4B	

DAS
15
9-89

B4B

pcs

Handfinish - 4 - 10 - B4B

Handfinish - 4 - 11 - B4B

Handfinish - 4 - 12 - B4B

Handfinish - 4 - 13 - B4B

Handfinish - 4 - 14 - B4B

Handfinish - 4 - 15 - B4B

Handfinish - 4 - 2 - B4B

Handfinish - 4 - 3 - B4B

Handfinish - 4 - 4 - B4B

Handfinish - 4 - 5 - B4B

Handfinish - 4 - 6 - B4B

Handfinish - 4 - 7 - B4B

Handfinish - 4 - 8 - B4B

Handfinish - 4 - 9 - B4B

*U/A painted @
step
160*

210 QC 5

32
pcs

8/27/19

0.00 32.00

QC 5 - 10

QC 5 - 12

QC 5 - 17

QC 5 - 18

QC 5 - 19

QC 5 - 22

QC 5 - 24

QC 5 - 3

QC 5 - 43

QC 5 - 49

QC 5 - 51

QC 5 - 58

QC 5 - 68

QC 5 - 9

QC 5 - 50

QC 5 - 30

QC 5 - 40

QC 5 - 61

QC 5 - 81

U/A

220 Packaging 3-1 - Stock - B4B

32
pcs

8/27/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

12

				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
230 QC 21 - SA	32 pcs	8/27/19	0.00 0.00	QC 21 - SA - 21	21 SEP 19 2019
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op **100** - 1-Disassemble jack as per drawing. See notes on sheet 3. 2-Remove foot as per drawing sheet 3.
 Descriptions: **110** - (QC5- Inspect part completeness to step on W/O)

115 - Drill and tap hole

120 - (QC5- Inspect part completeness to step on W/O)

130 - 1-Remove tubular mount from jack as per drawing. See note 2 on sheet 2. 2-Drill and ream 0.630" holes as per drawing sheet 3. Deburr. 3-Re weld tubular mount to jack at height shown. Foot not to be welded at this stage. 4-Identify parts accordingly for re-assembly after powder coat.

140 - (QC9- Inspect visual per QSI004- Fusion Welds)

150 - (QC5- Inspect part completeness to step on W/O)

160 - ***External tube only*** Fire Red(Ref:4.3.5.10) per QSI005 4.3) Mask as per note 8. START TIME: 9:30

OVEN TEMPERATURE: 375° FINISH TIME: 9:45

170 - (QC3- Inspect Part Finish)

180 - 1-Re-assemble jack as per drawing with previously removed components. 2-Weld -5 foot adaptor mount. Jack to be fully retracted prior to welding as per drawing Note 2, sheet 2. ***Take care not to scratch/damage powder coated area.***

190 - (QC5- Inspect part completeness to step on W/O)

200 - Mask of end of inner tube and spray paint RBT18402-5 fire red.

210 - (QC5- Inspect part completeness to step on W/O)

220 - (Identify as per dwg & Stock Location: 41001)

230 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
178151	Jack	32 Ea (1 ea)	100-Large Fab - Welded Assy-1	<u>5206067</u>
RBT18402-5	Foot Adapter Mount	32 pcs (1 ea)	130-Large Fab - Basket - 2 - B4B	<u>5206513</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	178151	32	0	0
130-Large Fab - Basket - 2 - B4B	RBT18402-5	32	0	0

Part Specifications

Specifications could not be found.

Entered: 2R Date: Nov 18/19

NCR No.

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only

Job: <u>197578</u> Part No. <u>RBT18402-1/</u>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date: <u>AUG 21/19</u>		Sequence #:		QTY Affected :		MRB (QSI042) <u>M. Lee</u> <u>AUG 21/19</u>			
Description Work Order Deviation RBT18402-1 HAS BEEN POWDER COATED RED PER DRAWING RBT18402 REQ. 1A. POWDER COAT IS FLAKING OFF OF PART.				Disposition MASK ALL EXPOSED AREAS OF JACK TO ENSURE SANDBLASTING WILL NOT AFFECT TECH. STRIP ALL REMAINING POWDER COAT. RESINUSH JACKS PER QSI005 4.2.1.3.2 AND 4.2.2.3 (RED) Primer S200299 Paint S211232				Completed By <u>AB 17-9-8</u> Lead hand / Supervisor <u>SB</u> <u>19/10/28</u> QC / QA Coordinator <u>DAS</u> <u>9</u> <u>9-89 19.10-31</u>	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☒ Part Lost/Missing ☐ Misread ☐				Other/Details: RED POWDER COAT RAL 3020 IS NOT ADEQUATE FOR THIS PURPOSE. (ROUTE CAUSE BRAND OF RED POWDER COAT)					